

5/28

DART AEROSPACE LTD	Work Order :	23612
Description: Step Extrusion	Part Number:	D2622-120C
Drawing: D2622 Rev. C1	Qty:	110 130
		Page 1 of 1






Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	DL	05.06.21	110
2	PG	Issue P/O: <u>7058264</u> a) Extrude as per Dwg D2622 Rev. C 05.02.10 CP b) Material: 6061-T6 (QQ-A-200/8) c) Minimum yield tensile strength = 35 ksi d) Minimum ultimate tensile strength = 38 ksi e) Minimum elongation = 8% f) Order at 120" long g) Bon L Canada Inc. tool # 897123 Rev. A h) To be packed per DSK 066 i) Pull test to ASTM standard B221 required. j) Material certification is required	LU	05.06.23	110
3	RG	Inspect for transit damage Ensure Certification are attached	DL	05/07/28	135
4	QC6	Inspect dimensions per Dwg D2622 Check Pull test per Dwg D2622 for compliance page attached. Check hardness with Webster tester	PD	05-08-23	130
5	ST	Identify and Stock as D2622-120C	DL	05-08-14	130
6	AC	Cost / part <u>24.33</u>	SUC	05-09-15	130
7	DC	Close W/O <u>24.10</u> Inspect Level 21	DL	05/09/15	130

Rev	Date	Change	Revised By	Approved
A	02.11.12	New Issue	KJ RF	DL

RELEASED
02.11.18 RF

PTO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-09-14	4	5X D2622-120C Scrpp due to not passing hardness test (x2) : deep scratches the whole length of extension x3		give to engineering for show stuff. <u>See NCR 925</u>	 05-09-14	 05-09-14	 05/09/14	 05-09-14

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 05/09/15

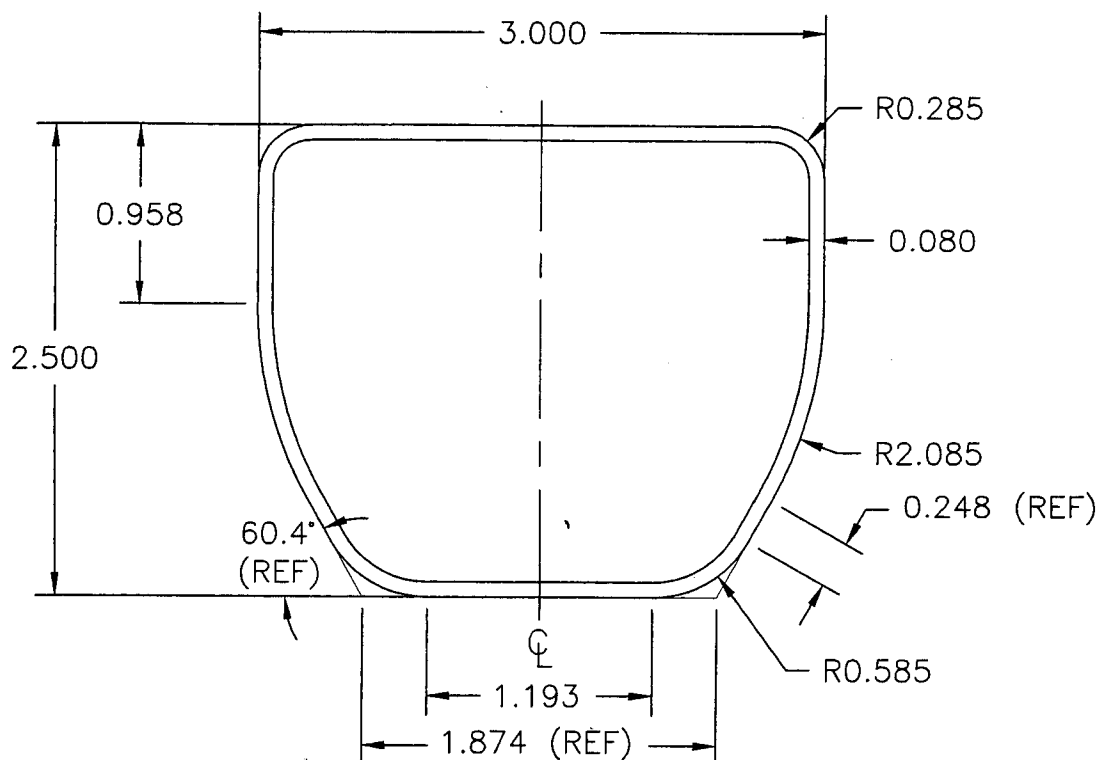
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN	KE	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D2622	REV. C SHEET 1 OF 1
DATE	02.09.11			TITLE STEP EXTRUSION	SCALE 1:1
A	96.11.29			NEW ISSUE	
B	97.12.12			CHANGE MATERIAL, ADD TOL. QSI	
C	02.09.11			0.080 WAS 0.085; ADD PART & DIE No.	
CI	#	CP	02.10.04	ADD 'REV. A' TO DIE NUMBER.	

RELEASED
02.09.11 #



D2622-XXX STEP EXTRUSION

- 1) PART NUMBER IS D2622-XXX WHERE 'XXX' IS CUT LENGTH IN INCHES (EG. D2622-120 IS 120" LONG)
- 2) MATERIAL 6061-T6 (QQ-A-200/8)
- 3) MANUFACTURED USING BON-L DIE # 897123 REV. A

- 4) A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE MINIMUM MECHANICAL PROPERTIES STATED BELOW:

MINIMUM TENSILE YIELD STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM ELONGATION = 8%

- 5) PART IS SYMMETRIC ABOUT CENTERLINE
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 23612

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jun 20, 2005
03:23 pm

Work Order No	: 0023612	Department Code:	
Project Name	: D2622-120C	Burden Flags	: NNNNNNNN
Project For	: WK528	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D2622-120C	Invoice Number	:
Description	: Extrusion	Invoice Amount	: 0.00
Manufactured	: Yes	Order Entry No	:
Amount Req'd	: 110	OE Value	: 0.00
Amount Done	: 0	Est Mark Up	: 0.000%
Start Date	: 06-20-05	Actual Mark Up	: 0.000%
Est Finish Date	: 07-20-05		
Act Finish Date	:		
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:		

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

**BON L CANADA INC**500 EDWARD AVENUE
RICHMOND HILL, ON L4C 4Y9**CERTIFICATE OF COMPLIANCE**

Cert Date	Cert No	Sales Order	Page
07/27/05	125092	58569	1
Cust PO	B/L No	Lot	Date
2008264	00271833	58569010	7/27/05

Sold To	Ship To
48024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	48024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Item No	Part No	Item Description	Cust Part
1.000	DAA-897123-1	120" Mill 6061 T6	D2622
Gross Weight	576 KGS		
Net Qty	556 KG	135 PC	411 M 2 PKG
Specification	AMS-QQ-A-200/8 & ASTM B221-00		Dia Desc

Mechanical Tests:					
Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/ Drift HR-E
1	281.4 / 40.8	250.4 / 36.3	11.9	.0	92
2	307.6 / 44.6	262.1 / 38.0	14.0	.0	92

Chemical Analysis:												
SI	FE	CU	MN	MG	CR	NI	ZN	GA	V	TI	ZR	OTHER

.640 .226 .231 .015 .852 .052 .005 .130 .000 .011 .013 .000 .000

This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

Paul Dailleboust, QA Manager Signed for Bon L Canada

